

# Work Order ID 59982

Tuesday, June 22, 2010 10:17:00 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 6/22/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date: 10-06-22 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: 111677

7- grind weld flush

8- deburr if necessary

SAD 10-06-29

⑥ 10-06-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Stop



Item Name: Rib Assembly (Inboard)

Start Date: 6/22/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 6.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

S 0606130



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

S 0606130



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: WA

0.00

SAD  
10-06-30



Packaging

Memo

0.00

Packaging

(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 59982**

Tuesday, June 22, 2010 10:17:00 AM

Page 3

Item ID: D3827-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Inboard)

Start Date: 6/22/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 7/26/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/30 *[Signature]*

MF

10-6-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 22, 2010 10:17:04 AM

Page 1

Work Order ID: 59982

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 6/22/2010

Required Date: 7/26/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1

Manufactured

No

100

Each

96.0000

3

18



Bushing

Location

Loc Qty

Loc Code

WA

96

54072

9

59419

45

59644

42

M304TS0.750W.065

Purchased

No

100

f

644.3207

8

50.52632



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

3.6996

112398

0

114482

3.6996

WA

640.621085

114520

640.621085

*10-06-29*

*18*

*SAD 10-06-29*

*50.5263*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

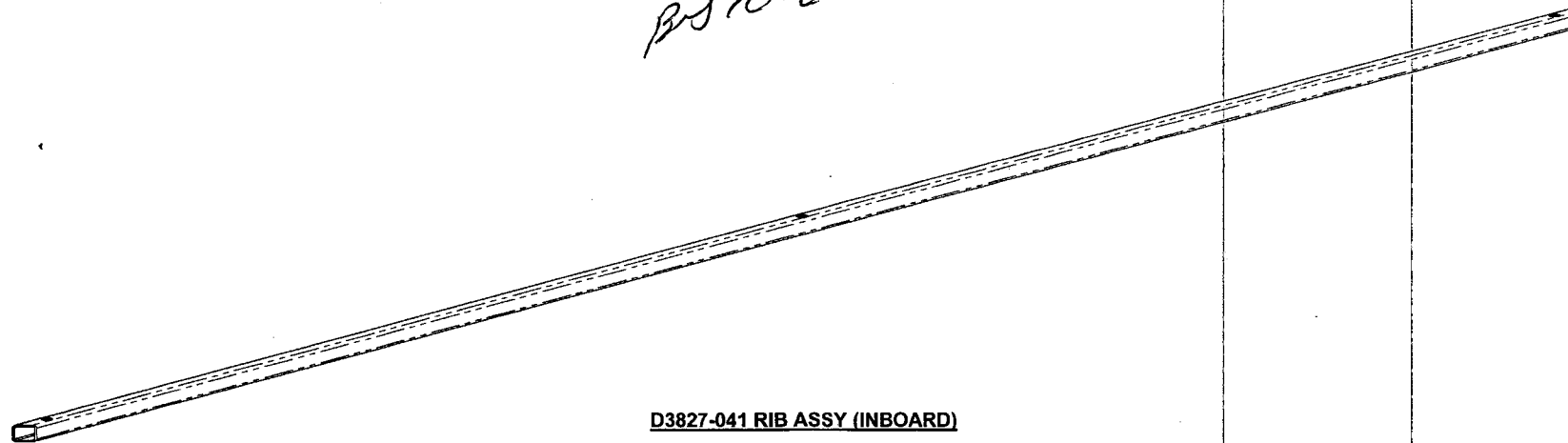
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**NOTE:** Date & initial all entries



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 59982  
BS 10-6-22



D3827-041 RIB ASSY (INBOARD)

RELEASED  
08/11/13

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 4.59 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D3827**

REV. A  
SHEET 1 OF 3

TITLE  
**RIB ASSY (INBOARD)**

SCALE  
NTS

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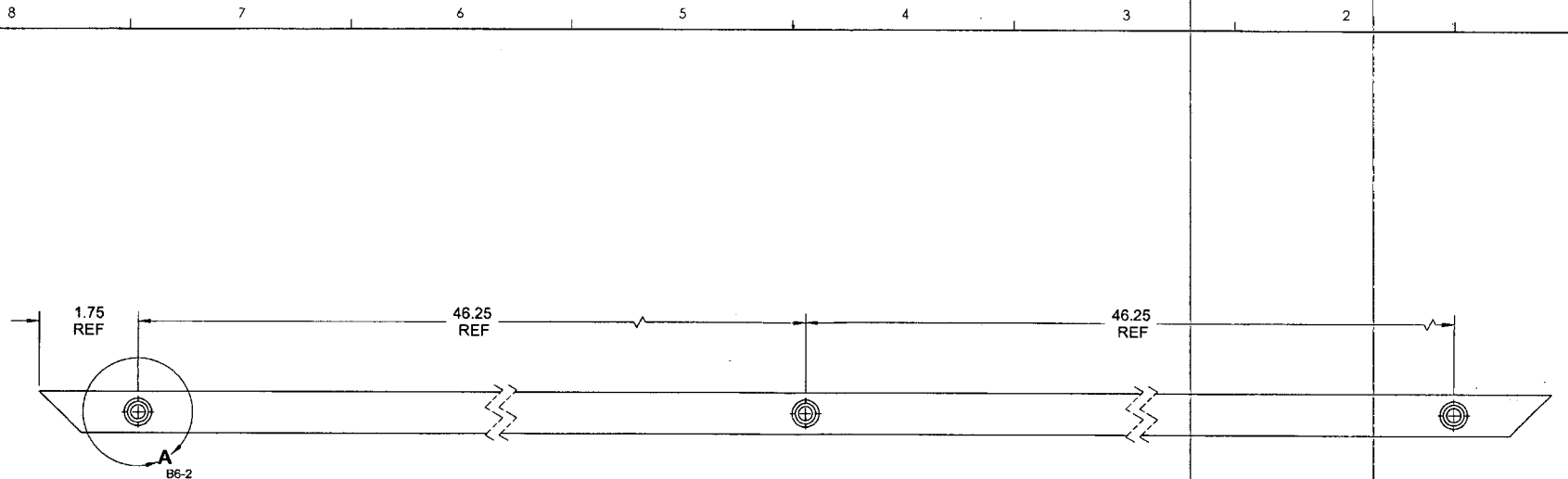
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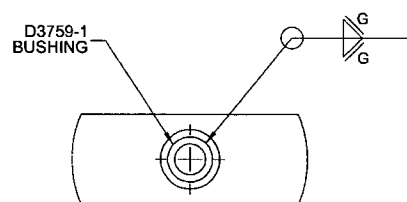
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**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X C7-2  
3 PL

*u/b 59982*

**RELEASED**  
*08/11/18*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MAO</i>	D3827	SHEET 2 OF 3
APPROVED	<i>MAO</i>	TITLE	SCALE
DE APPR.	<i>MAO</i>	RIB ASSY (INBOARD)	NTS
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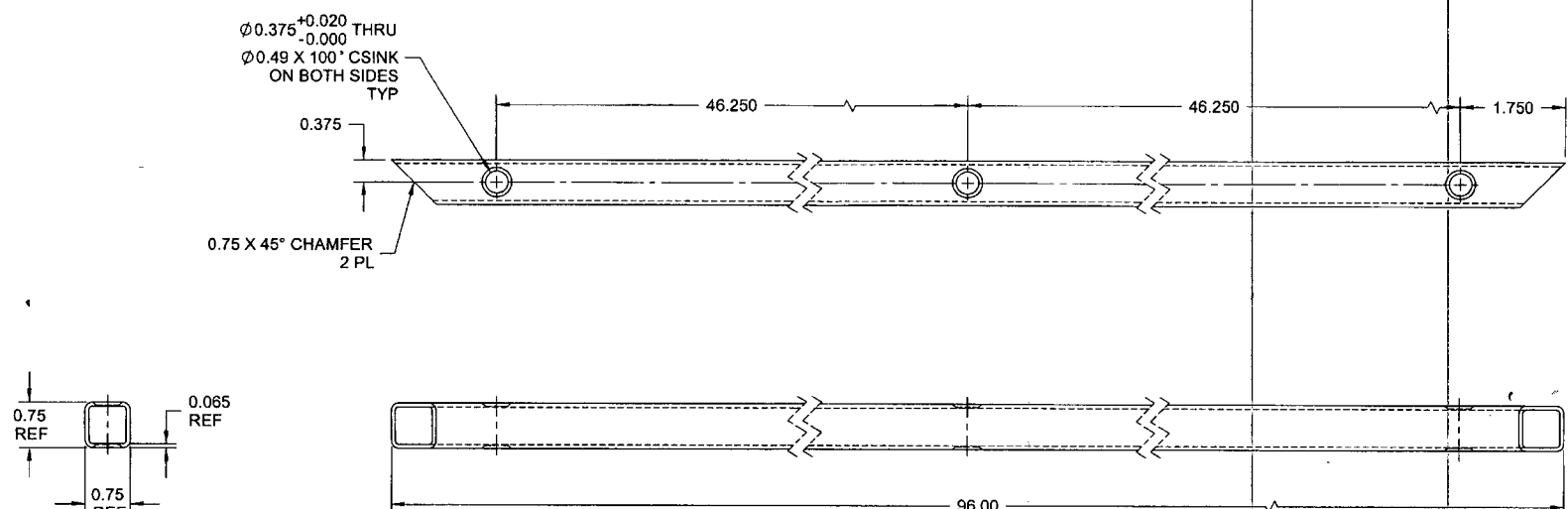
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WLO 59982



**D3827-1 RIB**

**RELEASED**  
08/11/14

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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